

Date: Thursday, 3/8/2007 3:41:03 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CUFF
 Job Number : 31150
 Estimate Number : 12774
 P.O. Number : *N/A* Part Number : D36061
 This Issue : 3/8/2007 S.O. No. : *N/A* Drawing Number : D3606
 Prsht Rev. : NC Project Number : *N/A*
 First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : *UNDER REVIEW* *OK 07.03.08*
 Previous Run : 31024 Material : *N/A*
 Due Date : 3/30/2007 Qty: 6 Um: Each
 Written By :
 Checked & Approved By : *07.03.08*
 Comment : est rev A new issue EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6R3500

Inventory



Comment: Qty.: 0.5250 f(s)/Unit Total : 3.1500 f(s)

6061-T6 round bar 3.500" dia.

batch: *B326548**section of D6009-129 x-Lube extrusion.*

2.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn as per folio FA & DWG D3606,

FOLIO REV: *N/A*DWG REV: *A*

2-Deburr as required

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.03.16	1	USE 7075-T6 ROUND BAR PER DWG				UP 07.03.16 QS1042	0703.21	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/03/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 3:41:03 PM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUFF

Job Number: 31150

Part Number: D36061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

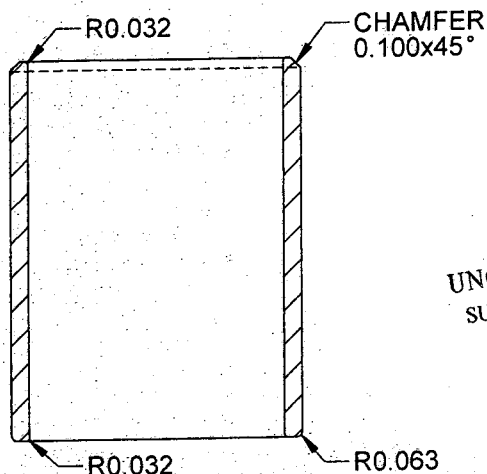
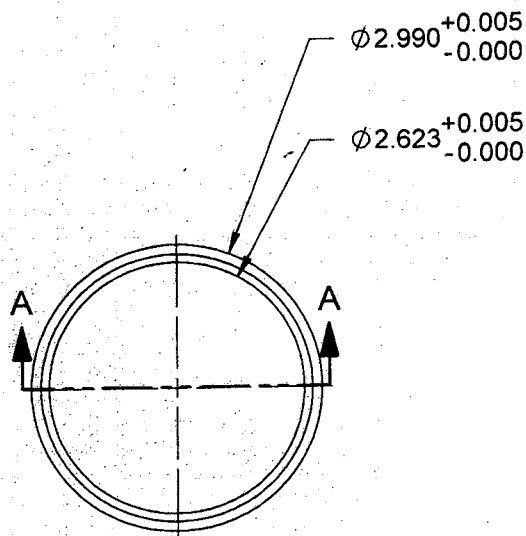
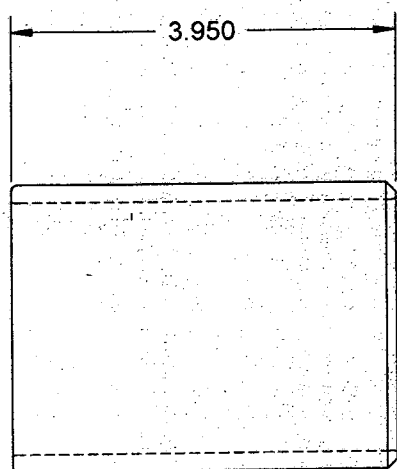
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN QP	DRAWN BY QP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3606	REV. A SHEET 1 OF 1
DATE 07.03.01	TITLE CUFF		SCALE 1:2
A	07.03.01	NEW ISSUE	

PRELIMINARY ISSUE
07.03.01



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31150

D3606-1 CUFF

NOTES:

- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)
(CAN MAKE FROM D6006, D6008, OR D6009)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DAR QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD		Work Order: 31150
Description: CUFF		Part Number: D3606
Inspection Dwg: D3606 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	3.950	$\pm .010$	3.948	✓			
B	$\phi 2.990$	$\begin{matrix} +.005 \\ -.000 \end{matrix}$	2.993	✓			
C	$\phi 2.623$	$\begin{matrix} +.005 \\ -.000 \end{matrix}$	2.625	✓			
D	.100 X 45°	$\begin{matrix} \pm .010 \\ \text{SEE} \end{matrix}$.102	✓			
E	R.062	$\pm .010$.062	✓			
F	R.032	$\pm .010$.032	✓			
G							
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K							
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V							
W							
X							
Y							

Measured by: BG	Audited by: En	Prototype Approval:	N/A
Date: 07.03.16	Date: 07/03/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
1		New Issue	KJ/RF	